

Date: Friday, 01/08/2008 10:43:41 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SHORT STEP ASSEMBLY HIGH SKID LH
Job Number : 40911	
Estimate Number : 10575	
P.O. Number :	Part Number : D350591213
This Issue : 01/08/2008 S.O. No. :	Drawing Number : D3078 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : A
Previous Run : 39477	Material :
Written By :	Due Date : 22/08/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JLD 08.8.05</u>	
Comment : Est Rev:B 05.10.14 Modified step 10 KJ/EC Est Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM Est Rev:C 06-06-27 Revised as per DSI9340 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.9.23

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-213 CHG002

S02602/25

2.0	D2622120C	Step Extrusion
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**Comment:** Qty.: 0.5000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2622-120C

Extrusion

B40937 ✓

SAD 08/09/16

(10)

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078

2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.

3-Deburr

SAD 08.09.16

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

S 08/09/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	D30671	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3067-1

End Plate

B 40854

SP 08.09.16 (10X)

6.0	D30631	Support
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

1 D3063-1

Description Batch

Support

B 41031

SP 08.09.16 (10X)

7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072

A/R Aluminum Rod

M 108350
M 108037

3-Grind End Plate flush

SAM

08/09/17

SP 08.09.16 (10X)

8.0	QC9	VISUAL WELDING INSPECTION
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Comment: VISUAL WELDING INSPECTION

9.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

10.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-H 08/09/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 40911

Part Number: D350591213

Job Number:



Seq. #: Machine Or Operation: Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-18

V10

12.0

D3065041

Step Leg Assembly Hi



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3065-041

Step Leg Assy

B38650 (1)
B39861 (9)

SAD

08/09/17

Q2

13.0

D30661

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3066-1

Spacer

40342 (7)

40850 (13)

SAD 08/09/17

20

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 16.0000 Each(s)/Unit Total: 160.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 MS20600AD4W4

Rivet

B108827

SAD

08/09/17

10

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3078.

SAD

08/09/17

10

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/18 V10 LH

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3067-1

End Plate

B40851

SP 08.09.18

10x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR: _____		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 40911

Part Number: D350591213

Job Number:



Seq. #: Machine Or Operation: Description :

18.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3078
A/R Aluminum Rod M108037

4-Grind End Plate flush

SAD 08/09/21 (10X) SP 08.09.18 (10X)

19.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08.09.22 (13)

20.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/22 (10LH)

21.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Touch Up Chemical conversion

M-1

08/09/22

(10X LH)

22.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

- Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:45
320°F
11:15

M-1 08/09/23

23.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3078 and QSI 005 4.4

M107892

FL 08/09/23

(10)

W/O:		WORK ORDER CHANGES					
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Job Number: 40911

Part Number: D350591213

Job Number:



Seq. #: Machine Or Operation: Description :

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

808/09/04 216411

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

26.0

D22301

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-1

Clamp

39315

50

27.0

D22303

Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2230-3

Clamp

1340341

50

28.0

D2732

Rubber Extrusion



Comment: Qty.: 1.0500 f(s)/Unit Total: 10.5000 f(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

4 D2732-030(3" LONG)

Rubber Cushion

337632

50

29.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total: 6.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2856-400(7.2")

Abrasion Strip

42008

8/9/22

10x

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 40911

Part Number: D350591213

Job Number:



Seq. #: Machine Or Operation: Description :

30.0 AN335A Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 AN3-35A Bolt M108827

31.0 AN411A Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 AN4-11A Bolt M106605

32.0 AN413A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Bolt

Batch: M107959

M109282

33.0 AN960JD10 Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN960JD10 Washer M105442

28
M109059

34.0 AN960JD416 Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN960JD416 Washer M103691

M104746

M105426

M107939

35.0 MS21042L3 ---Nut---



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M104625

M104936

8/6/02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number: 40911

Part Number: D350591213

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L4

Nut



10x

Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 MS21042L4

Nut (or -4)

1107499

8/9/22

sf

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8 08/09/25 1107499

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-213

Location:

PPP Rev:

Rev D

8 08/09/25 xC

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/25

Job Completion



U 08/09/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *#*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER
NO. *46911*

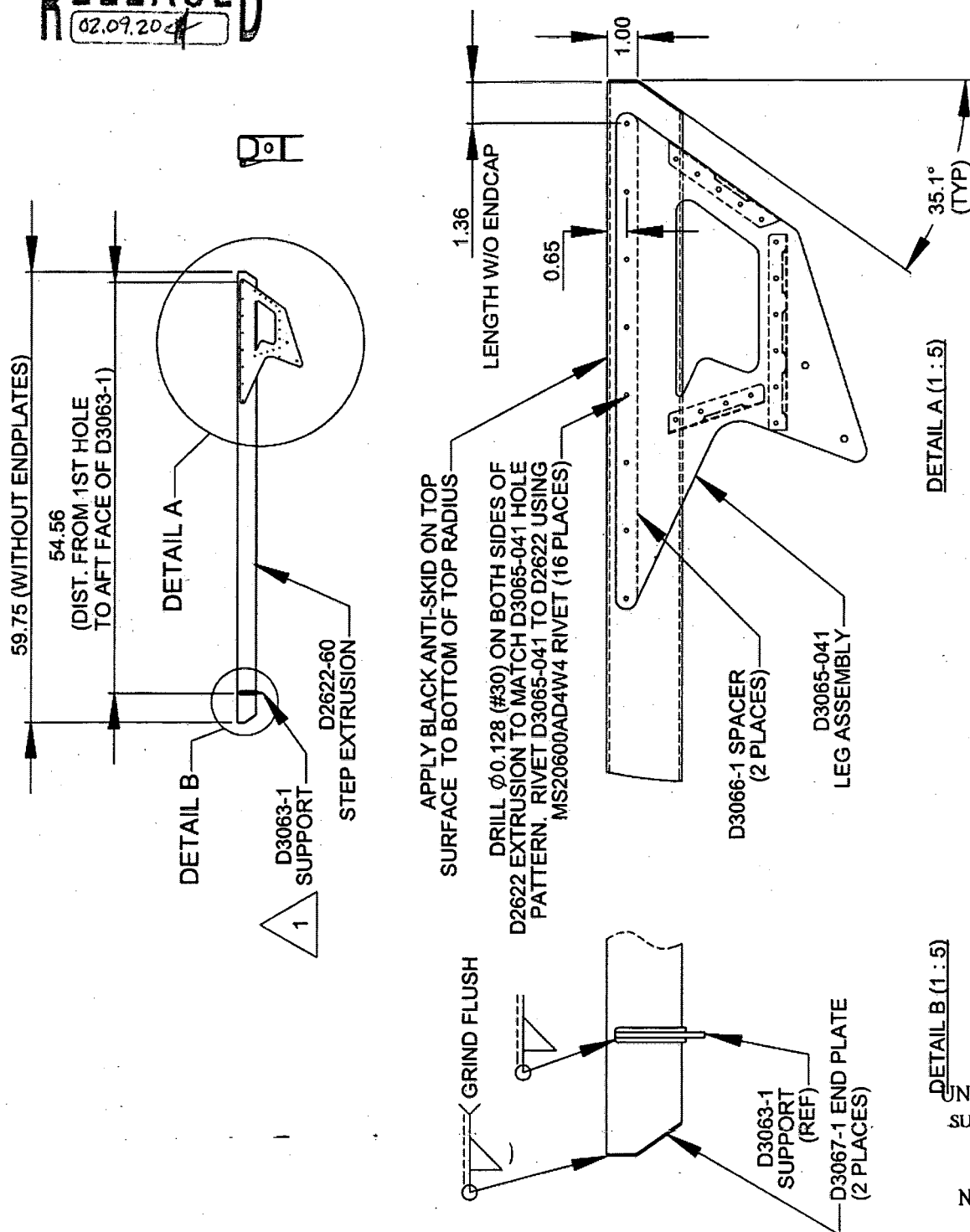
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DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3078	REV. A SHEET 2 OF 2
DATE 02.09.11	TITLE STEP ASSEMBLY, HI SHORT		SCALE 1:20

RELEASED
02.09.2011



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NO. 40911

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